











Date: Wednesday, 3/14/2007 3:33:00 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-BOLT SPACER
Job Number	: 31232		
Estimate Number	: 12469		
P.O. Number	: N/A	Part Number	: D35043
This Issue	: 3/14/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3504 REV B
First Issue	: 3/14/2007	Project Number	: N/A
Previous Run	: 28034	Drawing Revision	: B
Written By	: <u> </u>	Material	: N/A
Checked & Approved By	: <u> </u>	Due Date	: 3/21/2007
Comment	: Est Rev:A New Issue 06-06-20 JLM	Qty:	25
		Um:	Each

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0375W049	6061-T6 Tube .375 x.049W
		
Comment: Qty.: 0.2972 f(s)/Unit Total : 7.4288 f(s) 6061-T6 Tube .375 OD x.049W (M6061T6T0375xw.049) Batch: <u>M 10448</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
Comment: HARDINGE CNC LATHE SMALL 1-TURN AS PER FOLIO FA643 & DWG D3504 , FOLIO REV: <u> </u> DWG REV: <u> </u> } new prog. 2-DEBURR AS REQUIRED		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u> </u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/26

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: X-BOLT SPACER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(31)

Comment: FINAL INSPECTION/W/O RELEASE

D35043/26

Job Completion



4 D35043.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31232
Description: Cross Bolt Spacer		Part Number:	D3504-3
Inspection Dwg: D3504 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	0.375"	✓			
0.049	+/-0.010	0.051"	✓			
3.475	+0.030/-0.000	3.480"	✓			

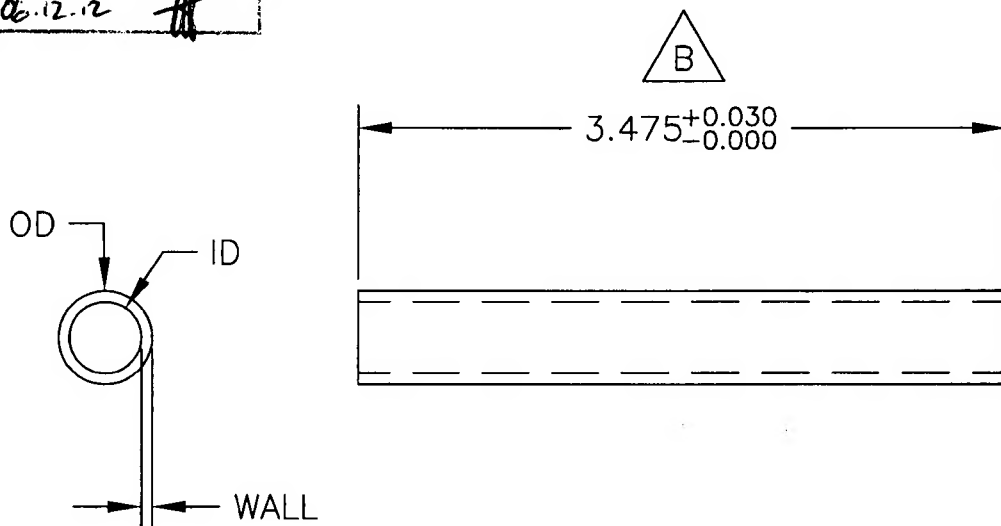
Measured by: J-F.	Audited by: MB	Prototype Approval:	N/A
Date: 07/03/22	Date: 07/03/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.03	New Issue	KJ/JLM	
B	06.12.14	3.480 revised to 3.475	KJ/JLM	



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3504	REV. B SHEET 1 OF 1
DATE 06.11.01		TITLE CROSS BOLT SPACER	SCALE 1:1
A	06.04.21	NEW ISSUE	
B	06.11.01	3.475 WAS 3.400	

RELEASED
06.12.12 *[Signature]*



D3504-1/-3 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3504-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3504-3	0.375	0.049	0.277	M6061T6T0.375W.049

D3504-1/-3 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31232*

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